

Date: Monday, 11/08/2008 10:20:21 AM
User: Linda Lacelle

Process Sheet

SPLIT - 2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 41082 -2	Part Number	: D35371
Estimate Number	: 12712	Drawing Number	: D3537 REV C
P.O. Number	:	Project Number	: N/A
This Issue	: 11/08/2008 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: 11/08/2008 Type : SMALL /MED FAB	Due Date	: 25/08/2008
Previous Run	: 38941	Qty:	64 100 Um: Each
Written By	:		
Checked & Approved By	: JLO 08.8.11		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
Comment: Qty.: 0.1113 sf(s)/Unit Total: 11.1300 sf(s) M304S16GA .063" 304 SS SHEET Batch: 108724 HB 8-8-14		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C HB 8-8-14 Prog Rev: C 2-Deburr if necessary HB 8-8-14		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-8-14		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 105 count.		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1 SB 08/08/19 105		



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Drawing Name: WEARPAD

Job Number: 41082

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

~~35~~ M108631, 108709, M109213

X 35

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

EL 8-10-7

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

center
S 08/10/07 (35)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/07 (35)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
3200°F
1:30

M-1 08/10/08

(35X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-08 (35)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-17

M 08-10-08 (35)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



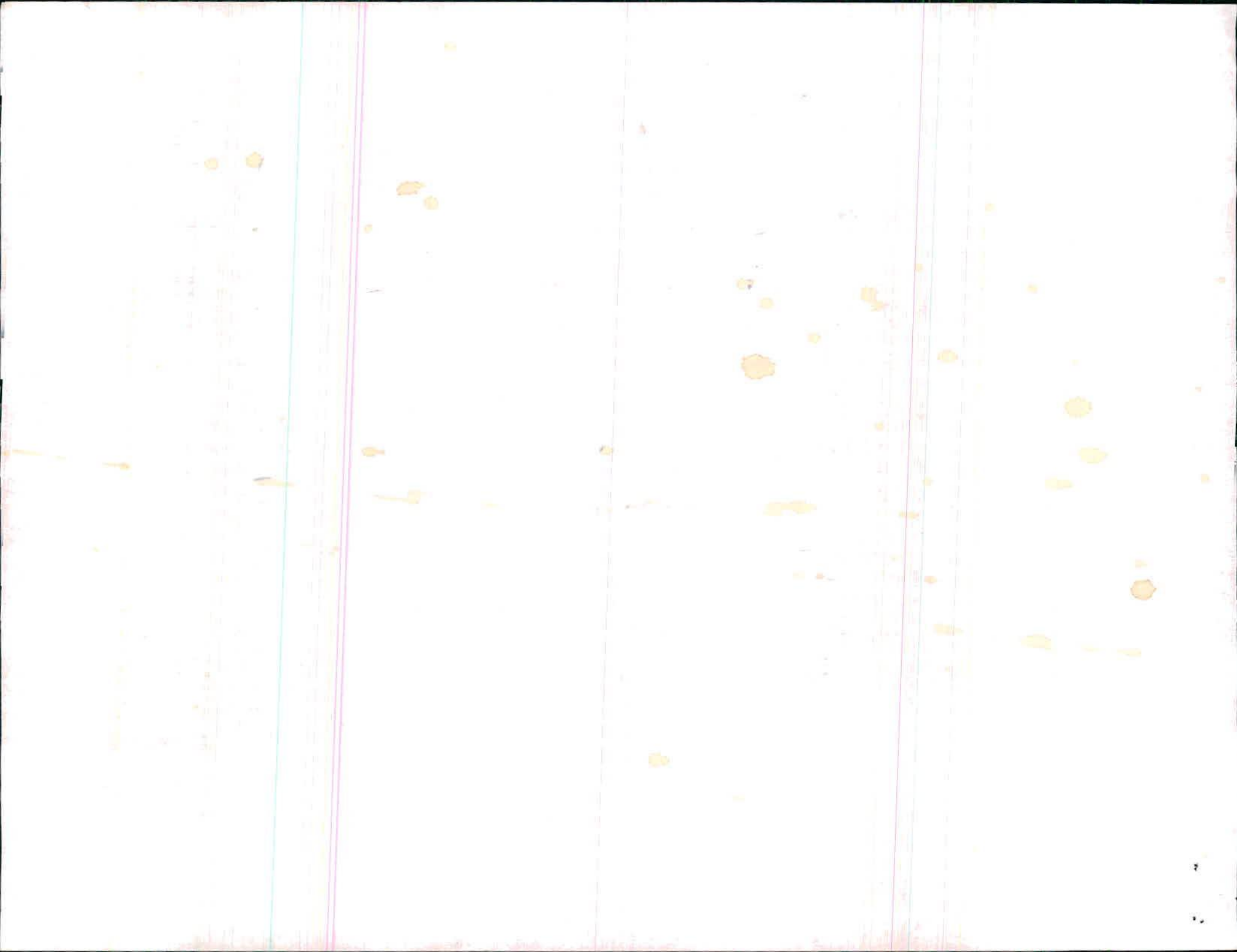
Comment: FINAL INSPECTION/W/O RELEASE

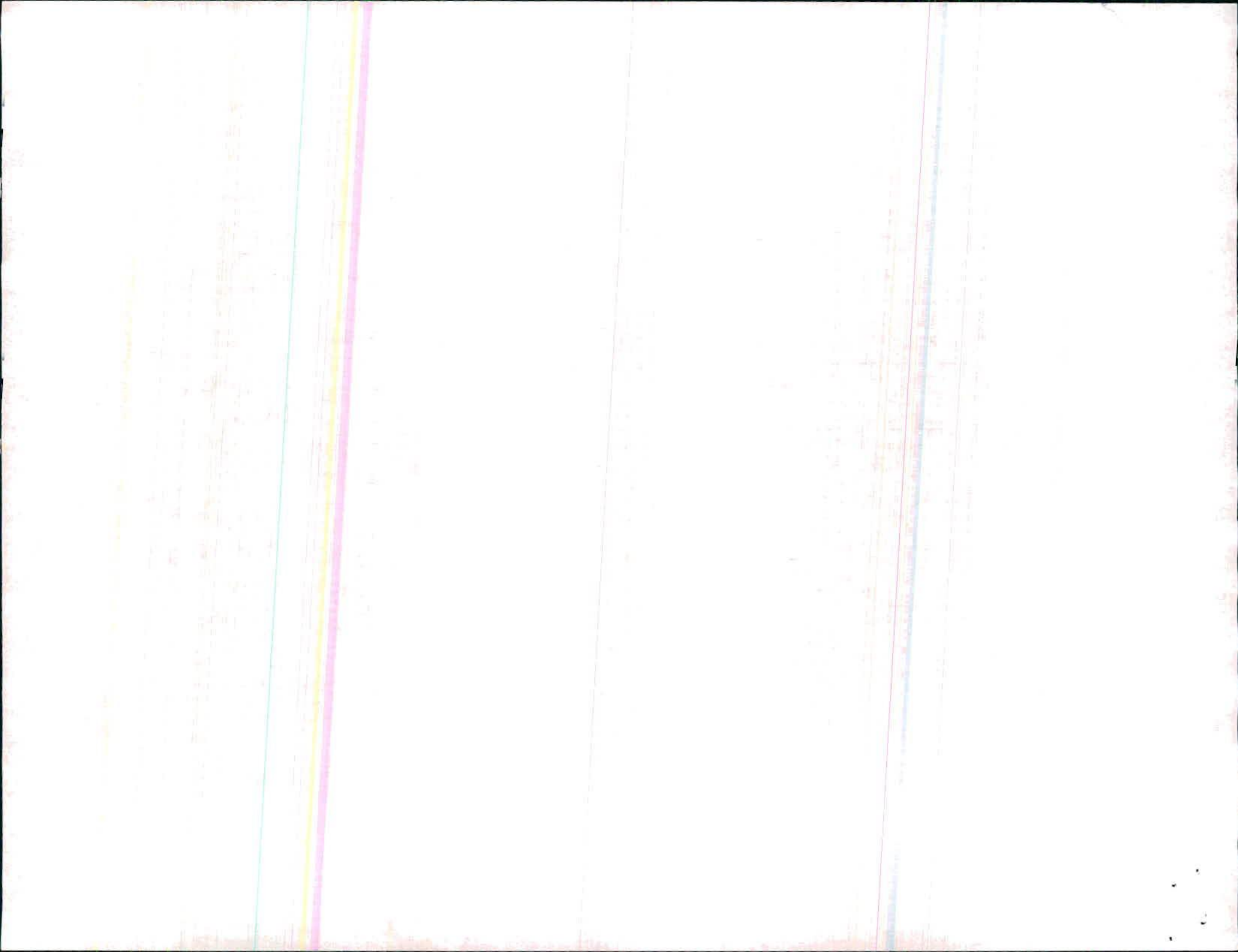
08/10/09 H

Job Completion

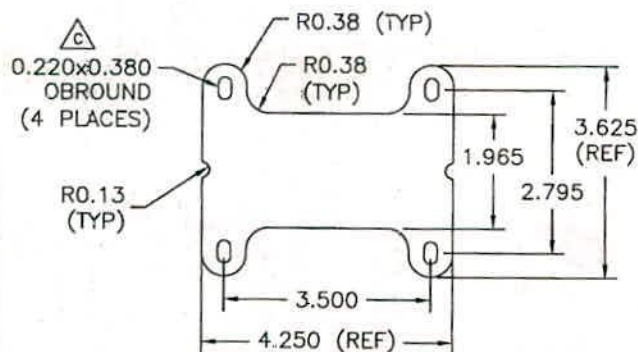


H 08-10-08

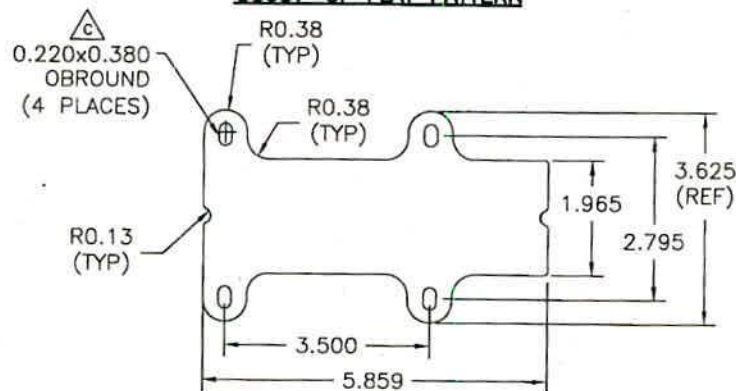




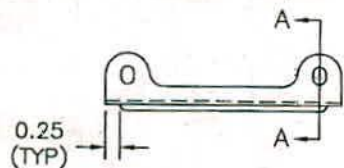
D3537-1F FLAT PATTERN



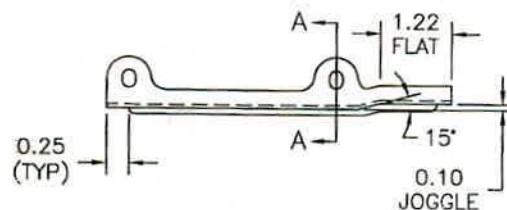
D3537-3F FLAT PATTERN



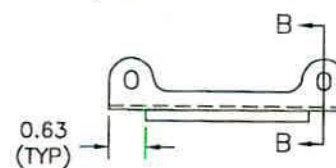
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



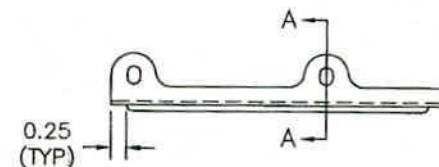
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



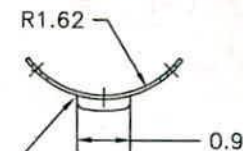
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

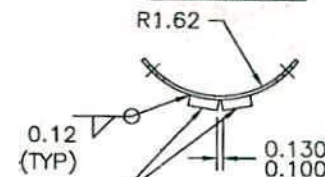


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07-05-08 PM
P21 EGN

D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	A	APPROVED A
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

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